

Work Order ID 57598

Friday, April 09, 2010 1:31:48 PM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 4/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 4/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: mfDate: 10-4-9

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3836	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAD 10-04-19

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 111679

6- grind weld flush where indicated on dwg

② Pl 10-04-19

130

QC9- Insp visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② Pl 10-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 06/04/20			(2) 2011			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00	SAD 10-04-20			(2)			
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/04/20 JF mf 10-4-20

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Picklist Print

Friday, April 09, 2010 1:31:47 PM

Page 1

Work Order ID: 57598

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 4/12/2010

Required Date: 4/15/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3

Manufactured

No

100

Each

31.0000

2.0000



Spacer Bushing



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

31

55917

11

57186

20

M304TS0.750W.065

Purchased

No

100

f

362.8531

3.7491



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

362.8530684

111148

58

113956

23.5

114137

281.353068

Pl 10-04-19

2

SAD 10-04-19

3.7491

Dart Aerospace Ltd

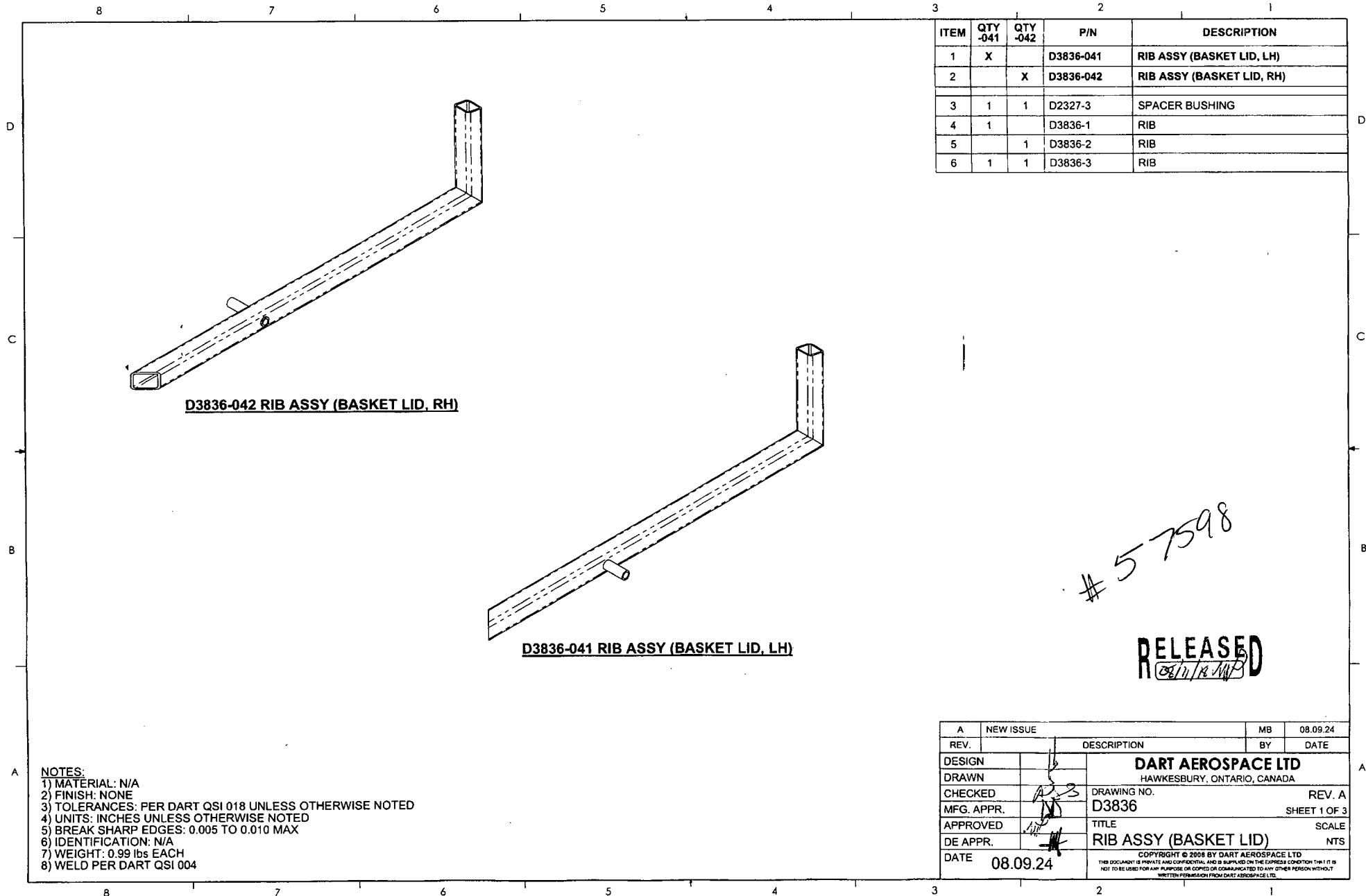
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB


D3836-042 RIB ASSY (BASKET LID, RH)

D3836-041 RIB ASSY (BASKET LID, LH)

57598

RELEASED
08/11/14 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION		BY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3836	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	RIB ASSY (BASKET LID)		NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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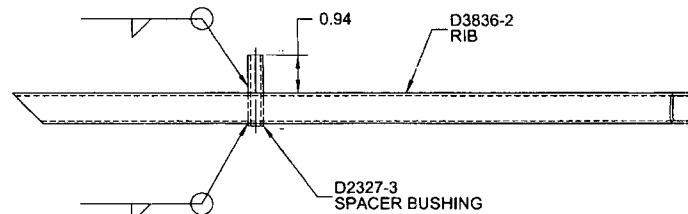
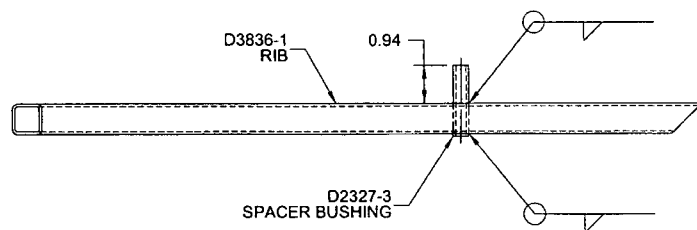
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

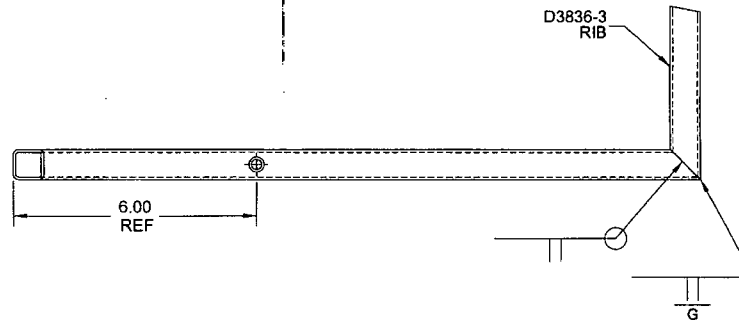
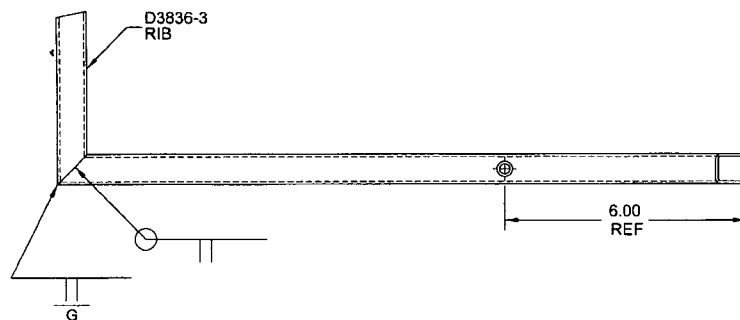
D

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C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

#57598

RELEASED
08/11/18 MTP

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
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DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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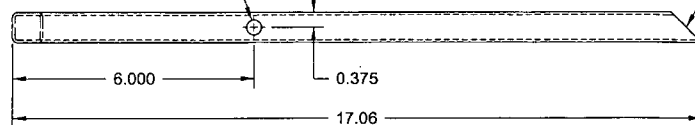
NOTE: Date & initial all entries

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CHAMFER

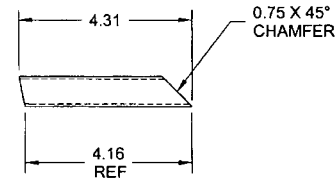


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0.75 X 45°
CHAMFER

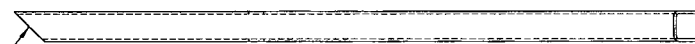


D3836-1 RIB



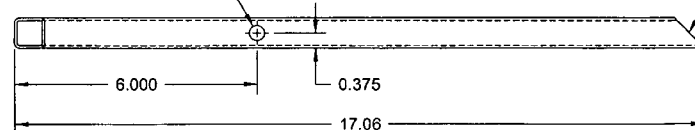
D3836-3 RIB

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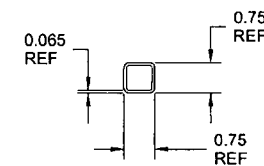


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
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